

Date: Wednesday, 1/30/2008 7:51:43 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FRAME WELDMENT
Job Number	: 37053		
Estimate Number	: 11202		
P.O. Number	:	Part Number	: D3330041
This Issue	: 1/30/2008 S.O. No. :	Drawing Number	: D3330 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: D
Previous Run	: 35439	Material	:
Written By	:	Due Date	: 2/20/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>9808 0130</u>		
Comment	: Est. A 05.01.13 New Issue KJ/JLM est B 07.05.14 revC dwg ec Est C 07.12.19 Rev D ecn1085 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D33301	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

✓	1	D3330-1	Panel	B35482
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JS 08/03/05

2.0	D33302	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

✓	1	D3330-2	Panel	B35486
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JS 08/03/05

3.0	D33303	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

✓	1	D3330-3	Panel	B35487
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JS 08/03/05

4.0	D33305	Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rail

Pick:

Qty Part Number Description Batch

✓

JS 08/03/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:51:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 37053

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1

D3330-5

Panel

B36011

JS

5.0

D33307

Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1 D3330-7 Panel B37081

JS

6.0

D33309

Top Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Top Plate

Pick:

Qty Part Number Description Batch

1 D3330-9 Panel B35488

JS

7.0

D333011

Long Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Long Pin Bracket

Pick:

Qty Part Number Description Batch

1 D3330-11 Long Pin Bracket B35483

JS

8.0

D333013

Short Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Short Pin Bracket

Pick:

Qty Part Number Description Batch

1 D3330-13 Short Pin Bracket B37079

JS

9.0

D333015

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch

1 D3330-15 Handle B37080

JS 08/03/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:51:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 37053

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

D333017

Handle Socket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Handle Socket

Pick:

Qty Part Number Description Batch

✓ 1 D3330-17 Handle Socket B35484

JS

11.0

D333019

Handle Rim



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Handle Rim

Pick:

Qty Part Number Description Batch

✓ 1 D3330-19 Handle Rim 30957

JS

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1
Identify as D3330-041

JS 08/03/05 (2X)

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-05 (2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/03/05 (2)

15.0

POWDER COATING

POWDER COATING



M 18052



(2X)

Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

m-l 08/03/05

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JS 08/03/05 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FRAME WELDMENT

Job Number: 37053

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: (STEVE)

HS 08/03/05

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/03/06

Job Completion



mi 2008/3/05 (2)

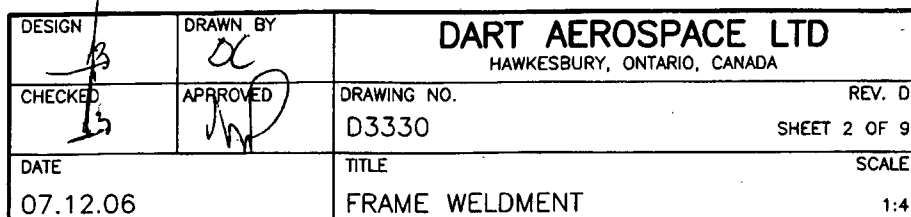
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

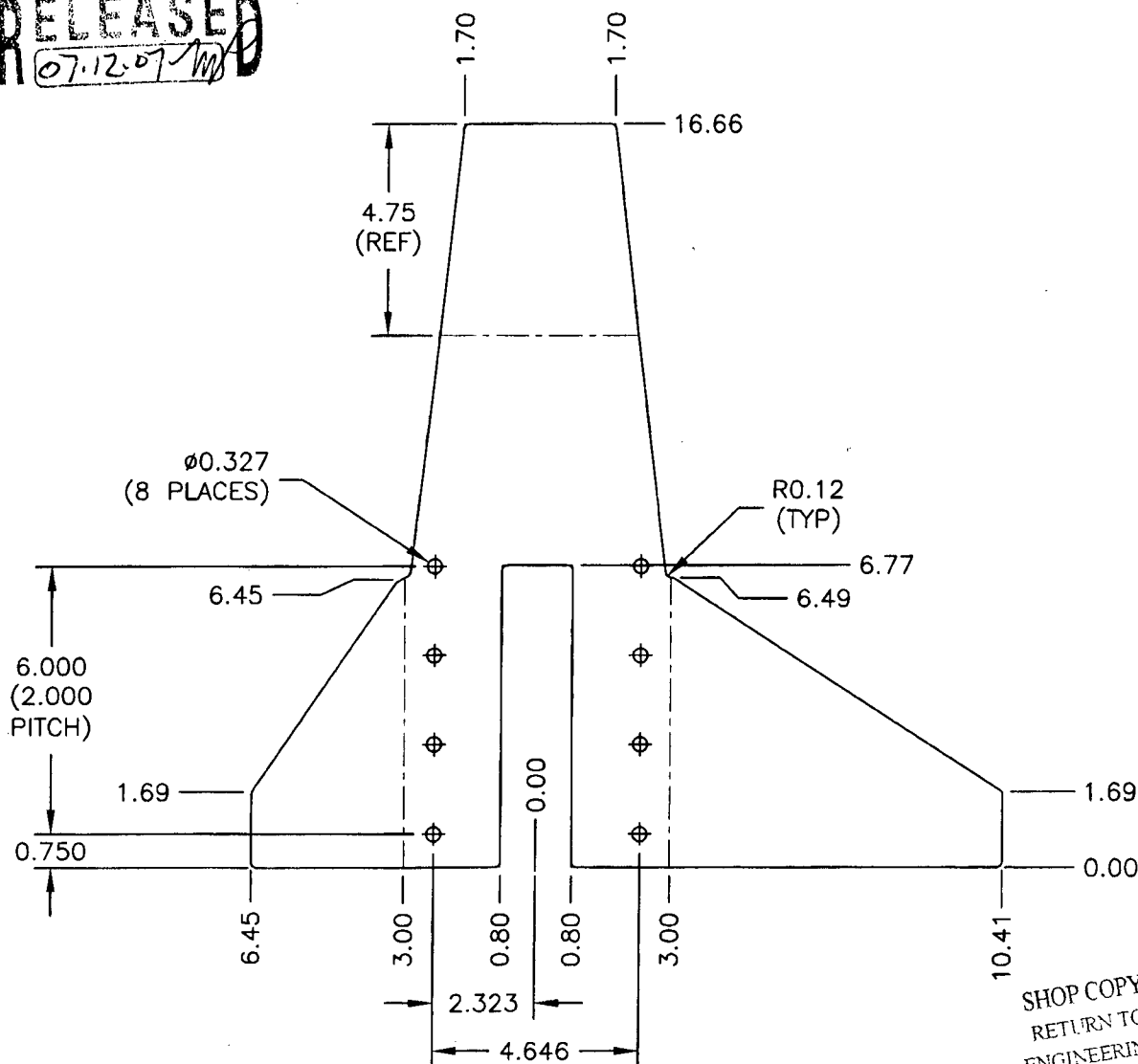
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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07.12.07



D3330-1 PANEL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

10
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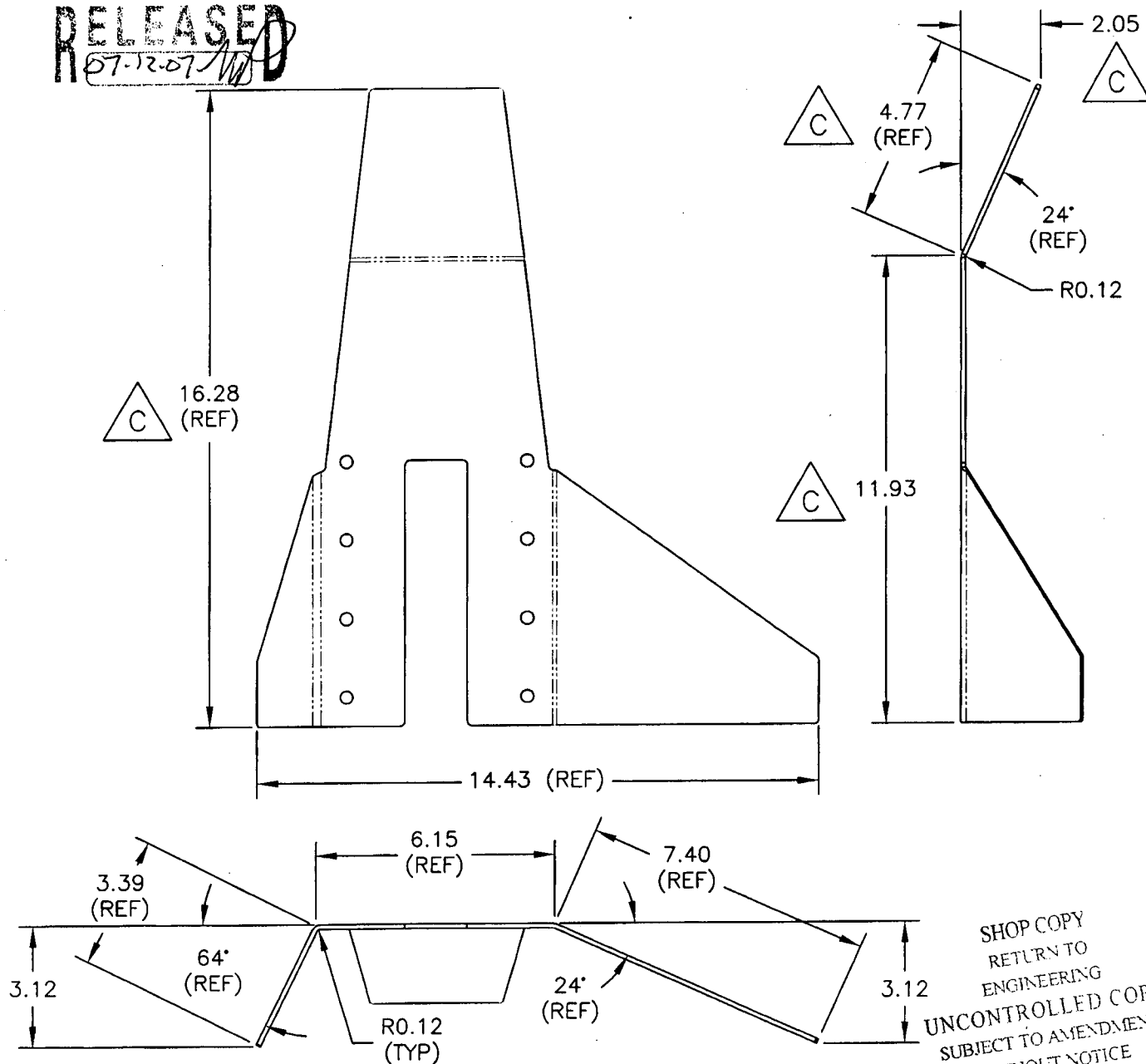
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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07-12-07



D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

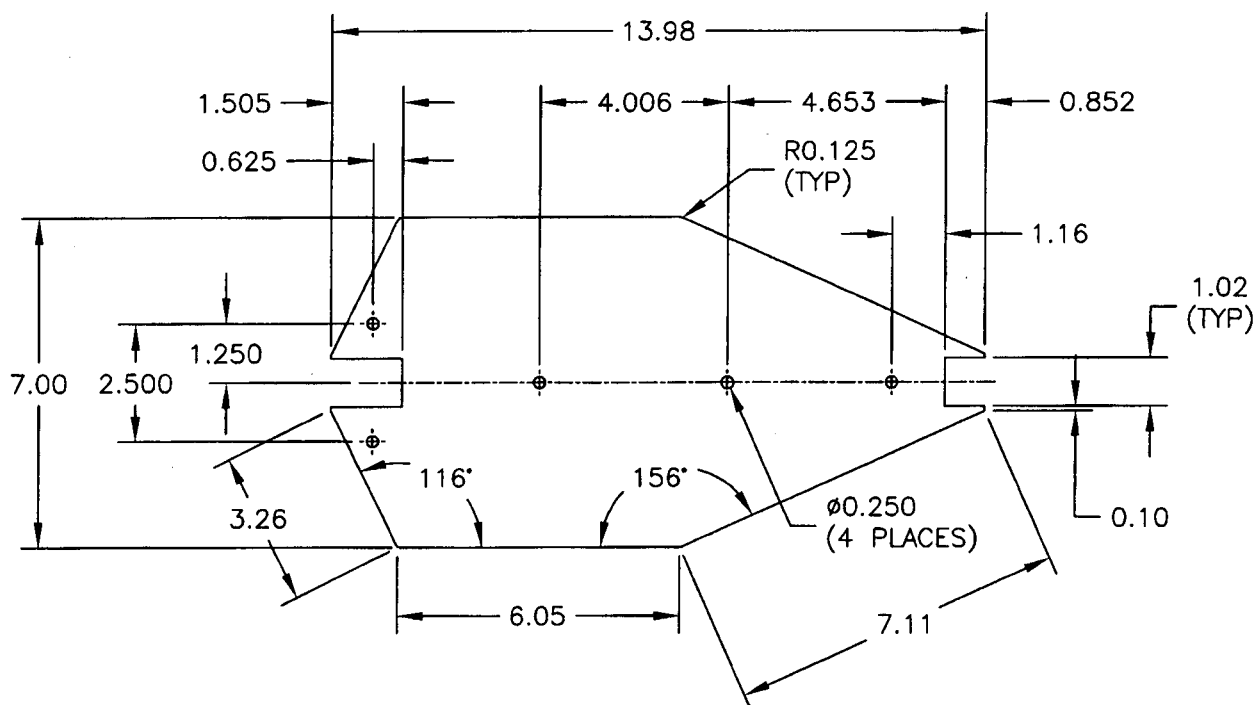
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RELEASED
07.12.07 [Signature]**D3330-3 PLATE**

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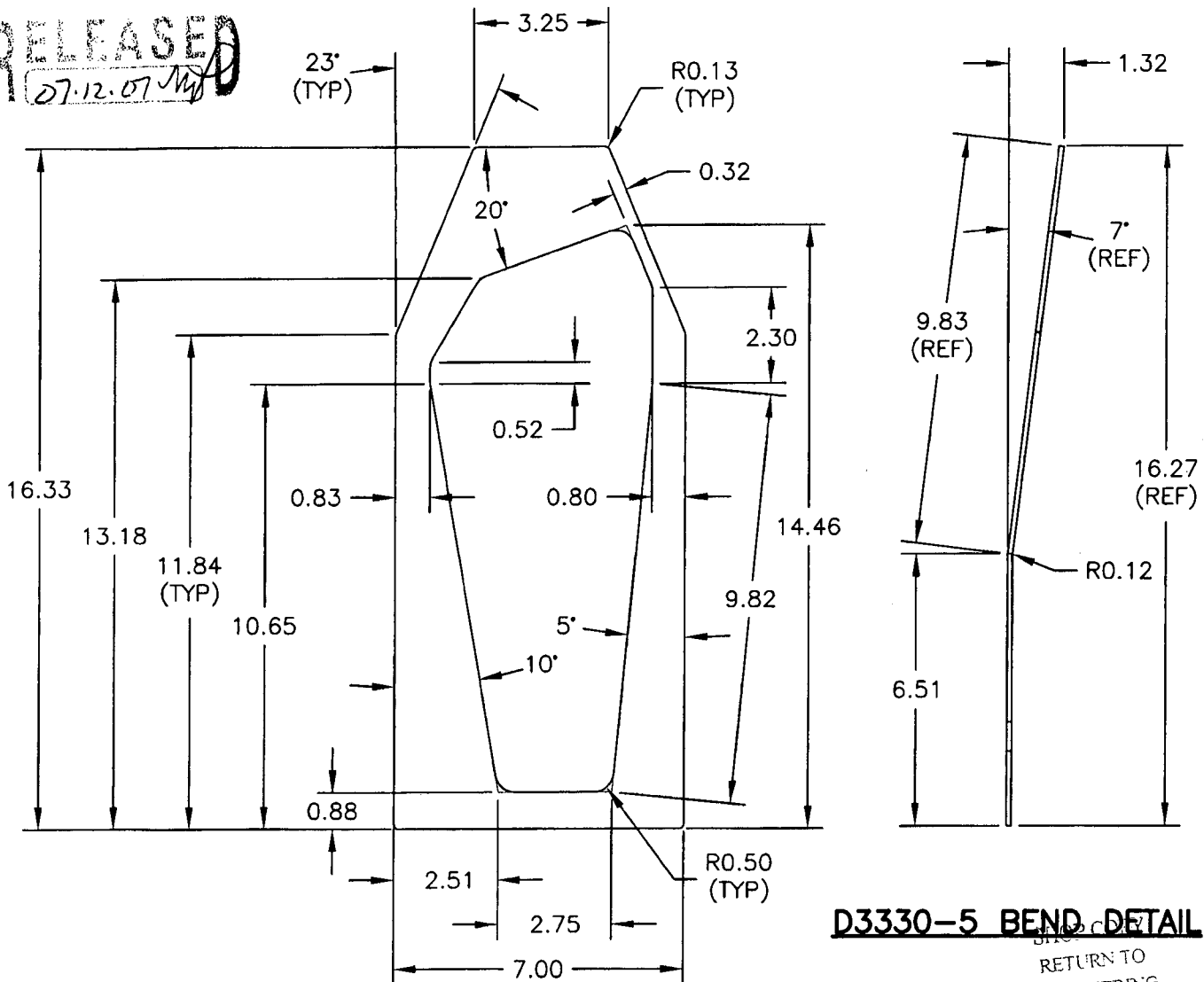
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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07.12.07 *MD***FLAT PATTERN****D3330-5 BEND DETAIL**RETURN TO
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NO. *37053***NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

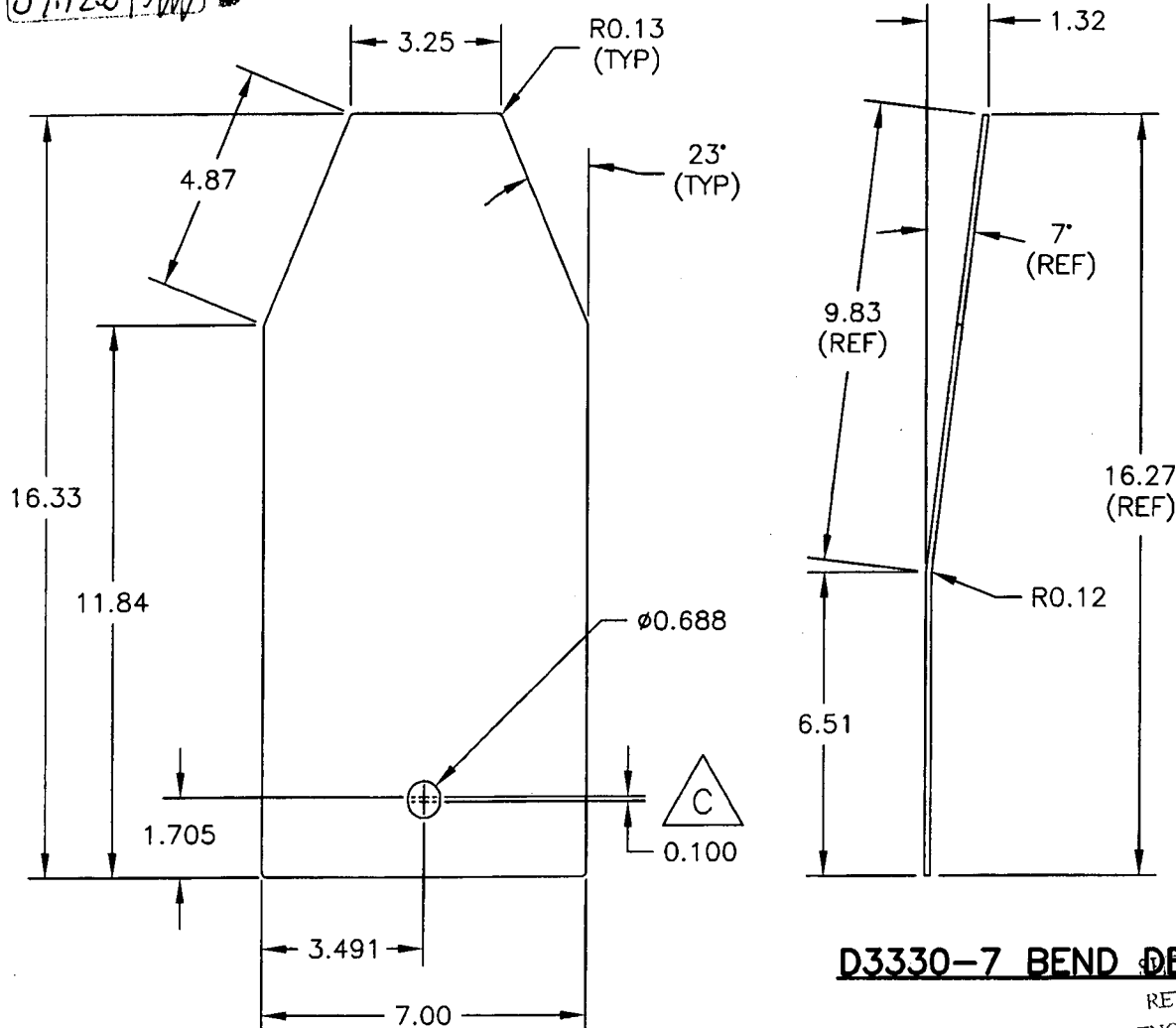
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DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

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FLAT PATTERN

D3330-7 BEND DETAIL

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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

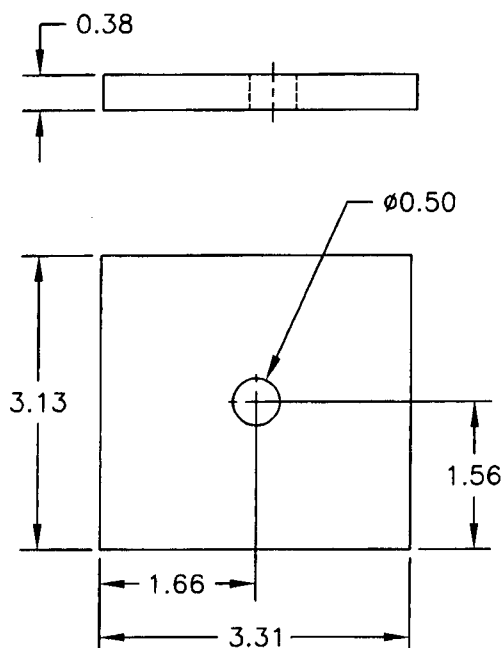
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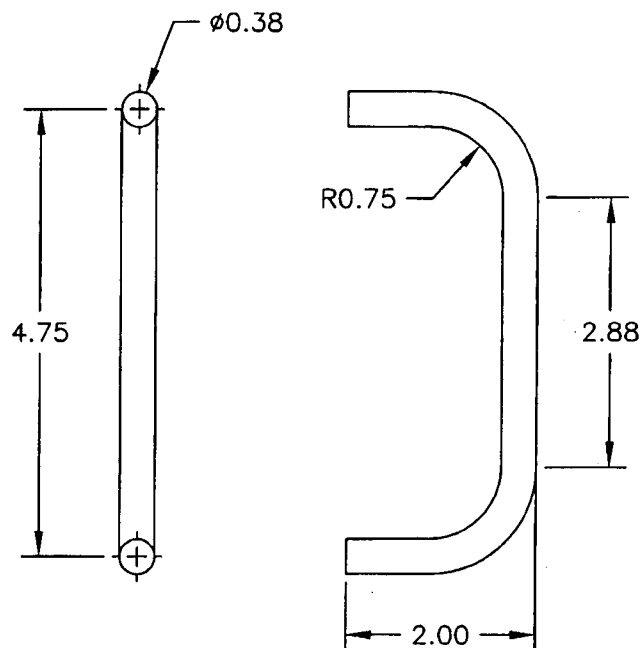


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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

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07.12.07



1 D3330-9 TOP PLATE



2 D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL (REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097 (REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

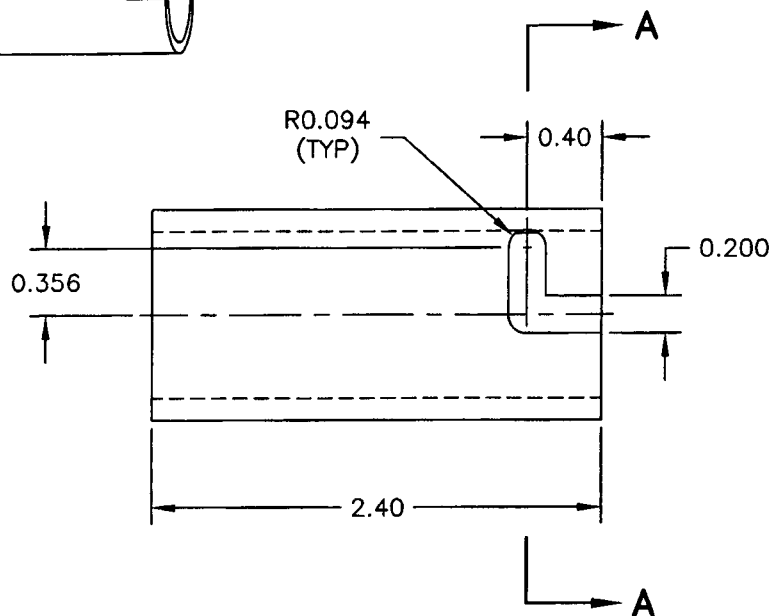
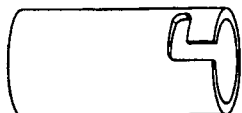
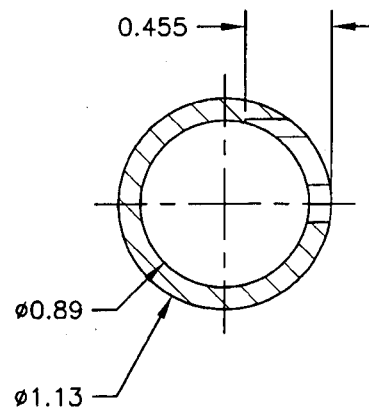
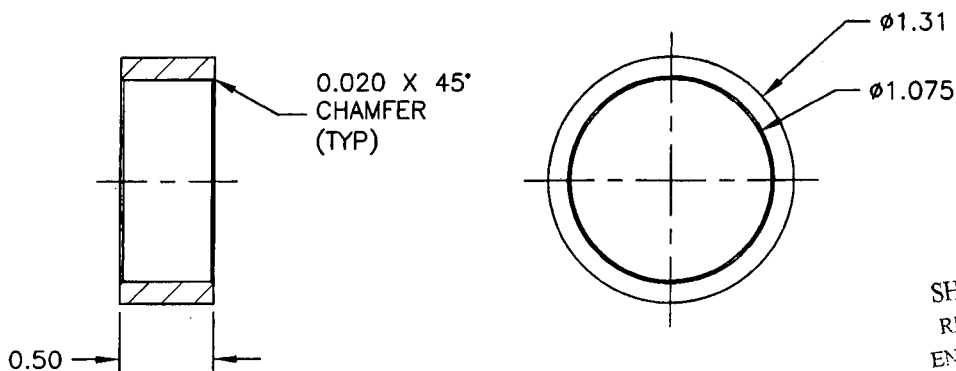
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:1

**RELEASED**
07.12.07 *[Signature]***SECTION A-A****D3330-17 HANDLE SOCKET****D3330-19 HANDLE RIM****NOTES:**

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

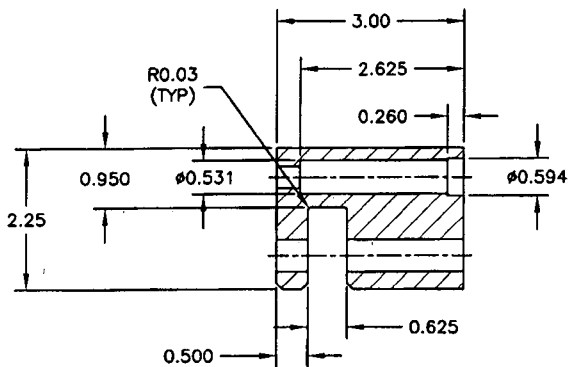
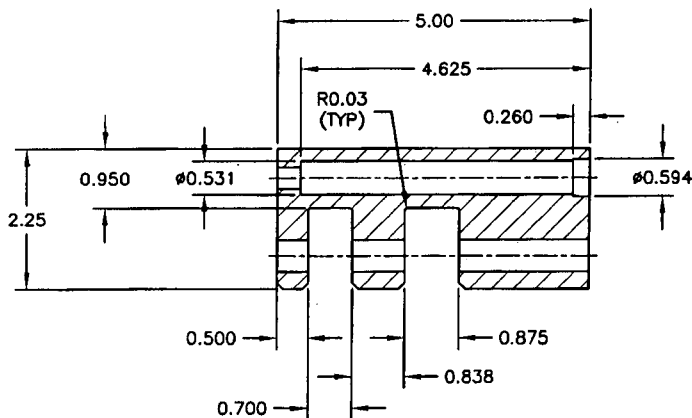
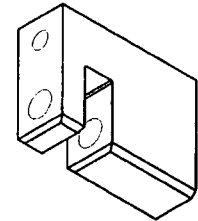
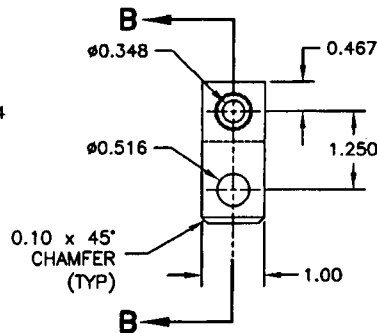
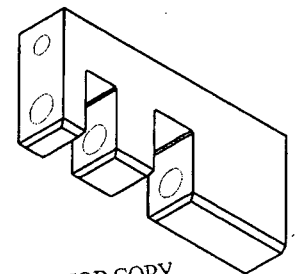
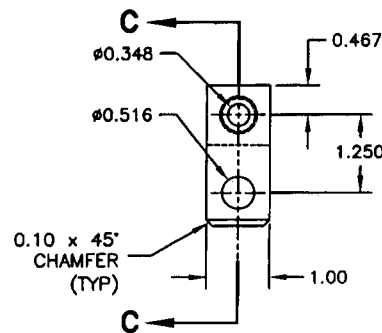
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

RELEASED
07.12.07 *[Signature]***SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET**

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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL
(REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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